

Work Order ID 67483

Tuesday, March 22, 2011 2:45:11 PM

PRELIMINARY ISSUE

Page 1

Item ID: D4323-2

Accept

Revision ID: PRELIM

Item Name: Cabin Wall, RH Aft

Start Date: 3/22/2011 Start Qty: 1.00

Required Date: 3/23/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4323

100

0.00

Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

105

0.00

Hand Thermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150°F

Time IN: 4:00 pm 11/03/02

Time OUT: 7:00 am 11/03/02

x (

DL
11/03/02

x (

DL
11/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67483

Tuesday, March 22, 2011 2:45:11 PM



Page 2

Item ID:	D4323-2	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Cabin Wall, RH Aft					
Start Date:	3/22/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	3/23/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 	Thermoform	0.00							
Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA100 using tool DT9727 Dwg Rev: <u>PAS</u> Folio Rev: <u>A</u>	0.00				x1			Dh 11/03/23
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	Memo	0.00				x1			Dh 11/03/23
Quality Control	Visually inspect part for proper formation and texture								
130 	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
									- Parts to be trained @ ease. Do not match Dwg. 5/10/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 67483

Tuesday, March 22, 2011 2:45:11 PM



Page 3

Item ID: D4323-2

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Cabin Wall, RH Aft

Start Date: 3/22/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandThermo Hand Finishing Thermoforming	Memo 1-Trim to finished dimensions as per Dwg	0.00 0.00							
150 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Complete FAI document	0.00 0.00							
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries



Work Order ID 67483

Page 4

Tuesday, March 22, 2011 2:45:11 PM

Item ID: D4323-2 Accept  Setup Start 
Revision ID: PRELIM Stop 
Item Name: Cabin Wall, RH Aft
Start Date: 3/22/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 3/23/2011 Req'd Qty: 1.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging	Identify as per dwg & Stock Location: _____	0.00							
Packaging	Memo <i>RSB 4/30/07</i>	0.00							<i>11/13/07</i>
180  QC	QC21- Final Inspection - Work Order Release	0.00							<i>11/15/16</i>
Quality Control	Memo	0.00							

POSITIVE RECALL

EFFECTIVE *11/03/13* AUTH *LN*
RELEASED *JM* DATE *11/05/13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, March 22, 2011 2:45:16 PM

Page 1

Work Order ID: 67483

Parent Item: D4323-2

Parent Item Name: Cabin Wall, RH Aft



Start Date: 3/22/2011

Required Date: 3/23/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.14 new issue DD verf:EC
Drawing Update 11/03/22

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	948.0376	15.9305	16.76895			



6185 KYDEX .080"

Location

therm

109703

116576

Loc Qty

948.037564

81.189115

866.848449

Loc Code



16.76895 sq ft

DL
11/03/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Daryl Leger

From: Daniel Campbell [dcampbell@dartaero.com]
Sent: Wednesday, March 23, 2011 9:21 AM
To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

Hi Daryl,

As per our conversation this morning, you can release the D4323-1/-2/-19/-20 parts for shipping to YYC without having trimmed them first. This means that the dimensions will not match the drawings, but since these are essentially "prototype" parts, they will be trimmed to fit here in YYC. The drawings will be modified as per the final fitting and trimming.

Cheers.

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road, NE, Calgary, Alberta, T2E 7G6

The information contained in this transmission is privileged and confidential and intended only for the use of the individual or entity to whom it is addressed. If you are not the intended recipient, you are hereby notified that any distribution, copying, disclosure or taking of any action in reliance on the contents of this transmission is strictly prohibited and review by any individual other than the intended recipient shall not constitute waiver of privilege. If you have received this transmission in error, please notify me immediately and delete the original transmission.

3/23/2011

Daryl Leger

From: Daryl Leger [dleger@dartaero.com]
Sent: Wednesday, March 23, 2011 10:15 AM
To: 'Daniel Campbell'
Cc: 'Harvey Siemens'; Linda Lacelle (llacelle@dartaero.com)
Subject: RE: D4323 Parts

Dan

I will do my best to ship the parts today.

Please note: If the parts are deemed acceptable, please notify the proper authority at Dart so that the positive recall can be removed on the Work Orders.

Daryl

From: Daniel Campbell [mailto:dcampbell@dartaero.com]
Sent: Wednesday, March 23, 2011 9:21 AM
To: 'Daryl Leger'
Cc: Harvey Siemens
Subject: D4323 Parts

Hi Daryl,

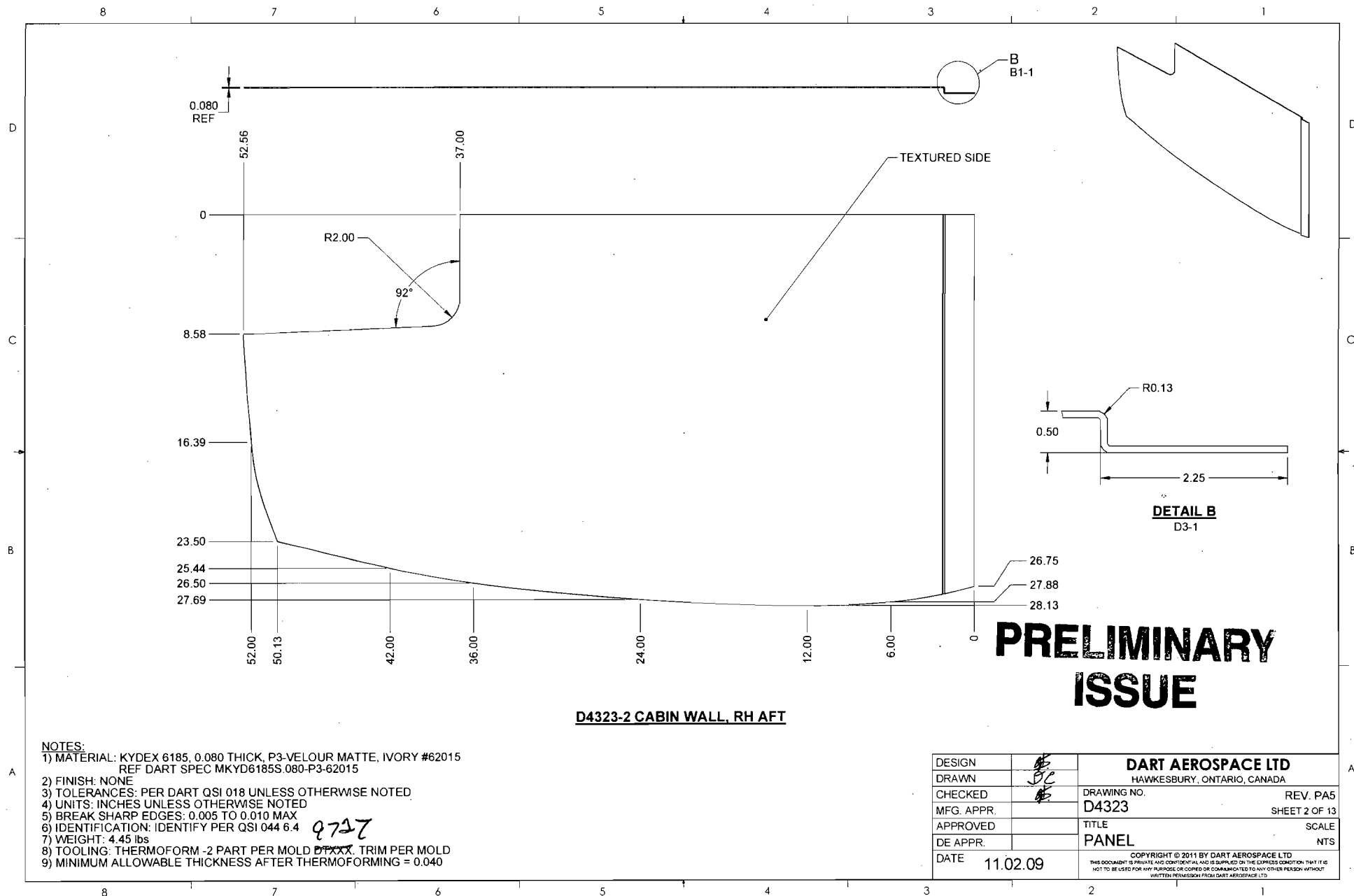
As per our conversation this morning, you can release the D4323-1/-2/-19/-20 parts for shipping to YYC without having trimmed them first. This means that the dimensions will not match the drawings, but since these are essentially "prototype" parts, they will be trimmed to fit here in YYC. The drawings will be modified as per the final fitting and trimming.

Cheers.

Daniel Campbell
Mechanical Engineer
DART Aerospace Ltd.

P: 403-717-0325
F: 403-717-1288
E: dcampbell@dartaero.com
W: www.dartaero.com

3/23/2011



NOTES:

- 1) MATERIAL: KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015
REF DART SPEC MKYD6185S.080-P3-62015
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4 **9727**
- 7) WEIGHT: 4.45 lbs
- 8) TOOLING: THERMOFORM -2 PART PER MOLD ~~DTXXX~~. TRIM PER MOLD
- 9) MINIMUM ALLOWABLE THICKNESS AFTER THERMOFORMING = 0.040

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>BC</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>BC</i>	DRAWING NO.	REV. PA5
MFG. APPR.		D4323	SHEET 2 OF 13
APPROVED		TITLE	SCALE
DE APPR.		PANEL	NTS
DATE	11.02.09	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

15315
6817 10000

1

